

# Work Order ID 84935

May-29-12 3:00:43 PM

**\*84935\***

Page 1

Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/29 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2906

Rev B

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPR D205-669-043 Chg 002

**SCRAP**

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

CF 12-6-18

SAO 12-06-18  
7/5 12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/15	140	Fwd bend is over bent. height = 2.20"	GP 12/7/15	Acceptable			GP 12/7/15	

NOTE: Date & initial all entries

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Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC3- Inspect Part Finish

0.00

**\*120\***

QC

Memo

0.00

Quality Control

(1) SAD 12-06-18

130

Skidtubes

0.00

**\*130\***

Skidtubes

Memo

0.00

Skidtubes

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date: 12-9-12

Start Time: 15:45

Date: 12-6-18

Fin Time:

Date:

pick:

Qty

P/N

description

1

D2926-3

Web

B/N

84949

CE/D 12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 29/05/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

**\*140\***

BENDING MACHINE - CROSSTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT

2-Cut tubes as per Dwg. D2906

CF/A

12-6-19

PTQ

150

0.00

**\*150\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

-Deburr ends and remove marks from bending

- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.

DC 12/07/06

CF 12-1-9

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

W/O: 84935		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-7-9	140	QC6 needs to be added after Bending		12-29			

Part No: D709-1069-043 PAR #: \_\_\_\_\_ Fault Category: Landing Gear Slip tube NCR: Yes No DQA: Yes No Date: 12/7/17

Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 12-1583		WORK ORDER NON-CONFORMANCE (NCR) #514.03						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-7-9	140	Tube Not cut properly after bending. 13.4" (Ref) Measurement is 12.2" and 18.9" (Ref) Measurement is 19.5"	 12-7-10	SCRAP P 12/7/9	 12-7-10	SCRAP 12-07-10	 12-07-10	 12/6/09
		RC; Employees error, Tube was not positioned properly on Saw Table.						
		Restrain employees PA; Add QC6 after bending	employees were trained					

NOTE: Date & initial all entries

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 29/05/2012      **Start Qty:** 1.00

**\* 1 \***

**Customer:**

**Required Date:** 16/07/2012      **Req'd Qty:** 1.00

**\* 1 \***

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00

**\*170\***

## Large Fab

0.00

## Skidtubes

## Skidtubes

## Memo

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Debur

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr

-Drill pilot holes for Tow ring using DT8091-3 , open to .640"and Deburr

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

## Memo

0.00

QC

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Setup Start \*NS1\*

Stop. \*NS2\*

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

200

HandFinish

## Hand Finishing

Pressure Wash per QSI005 4.3

## Memo

0.00

0.00

Tool #

**Plan  
Code**

**Accept Qty**

Reject  
Qty

### Reject Number

**Insp.  
Stamp**

210

**Powdercoat**

### Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

## Memo

START TIME: \_\_\_\_\_  
OVEN TEMPERATURE: \_\_\_\_\_  
FINISH TIME: \_\_\_\_\_

0.00

0.00

220

QC

## Quality Control

### QC3- Inspect Part Finish

## Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 \_\_\_\_\_

Sikaflex expire date: \_\_\_\_\_

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd &amp; Aft Cap as per Dwg D2906 and seal Fwd &amp; Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 \_\_\_\_\_

Sikaflex expire date: \_\_\_\_\_

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
250		0.00							
<b>*250*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD209-669-043 Location: _____ PPP Rev: _____								
260	QC21- Final Inspection - Work Order Release	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									

1/207-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 84935

**\*84935\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD  
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 <b>*D4202-1*</b> Spacer		Manufactured	No				Each	81.0000		19			
									**			DE 12/07/06	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>		(19)	
				LG			5						
				77727			5						
				LG002			76						
				78806			6						
				79810			70						
D2500-1-190 <b>*D2500-1-190*</b> Ext'n -1' Beam Tube 4"		Manufactured	No			110	Each	91.0000	1	1			
									**			CF 12-6-18	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				HALL			91						
				74777			14						
				80061			77						
D2926-3 <b>*D2926-3*</b> Web		Manufactured	No			110	Each	0.0000	1	1			
									**			1	CF 12-6-18
D2855 <b>*D2855*</b> Cap		Manufactured	No			230	Each	21.0000	2	2			
									**				
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				FP002			21						
				65519			2						
				73347			16						
				75074			3						

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

\*AN3-5A\*

\*\*

Bolt

Location

Loc Qty

Loc Code

ST350

1090

115371

46

117423

124

118626

31

119355

200

120187

500

121185

189

AN960JD10L

NAS1149D0332J

Purchased

No

230

Each

0.0000

4

4

\*AN960JD10L \*

\*\*

Washer

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

\*ALS7-1032-130\*

\*\*

Insert

Location

Loc Qty

Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

2085

119530

73

120181

12

121444

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

\*AN3C4A\*

\*\*

BOLT

Location

Loc Qty

Loc Code

ST350

1458

120187

57

120521

28

120769

38

121205

1000

121556

335

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

0.0000

44

44

\*AN960C10L \*

\*\*

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

\*D2594-3\*

\*\*

O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP001

2418

65518

41

79496

984

79573

50

79755

1343

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1 Manufactured No

230

Each

311.0000

14

14

**\*D2594-1\***

**\*\***

Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP001

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590

213

D3564-9 Manufactured No

230

Each

22.0000

1

1

**\*D3564-9\***

**\*\***

Wearshoe

Location

Loc Qty

Loc Code

FG

4

76950

4

FP001

18

67590

4

69943

1

82255

13

D3564-11 Manufactured No

230

Each

8.0000

1

1

**\*D3564-11\***

**\*\***

Wearshoe

Location

Loc Qty

Loc Code

FG

4

77056

4

FP001

4

80341

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

**\*D3564-5\***

**\*\***

Wearshoe

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

11

77609

3

82254

8

D3566-1

Manufactured No

230

Each

31.0000

2

2

**\*D3566-1\***

**\*\***

Gasket

Location

Loc Qty

Loc Code

FP

-22

81619

10

FP002

53

68924

2

80919

3

83898

16

D3566-5

Manufactured No

230

Each

21.0000

1

1

**\*D3566-5\***

**\*\***

Gasket

Location

Loc Qty

Loc Code

FP

12

82275

12

FP002

9

80374

3

82274

6

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER



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WORK ORDER  
NO. 84935 MLT  
12/05/2009

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG CW D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.21		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2906	REV. B SHEET 1 OF 3
TITLE AH-1 (209) SKIDTUBE ASSEMBLY	SCALE NTS

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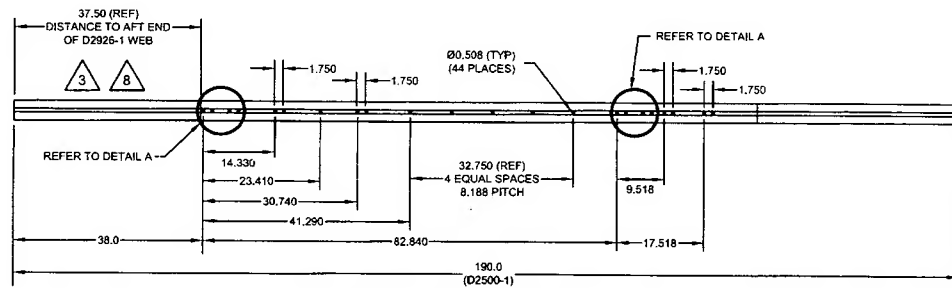
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

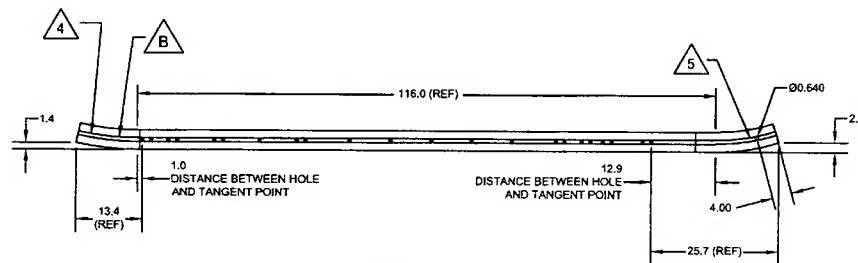
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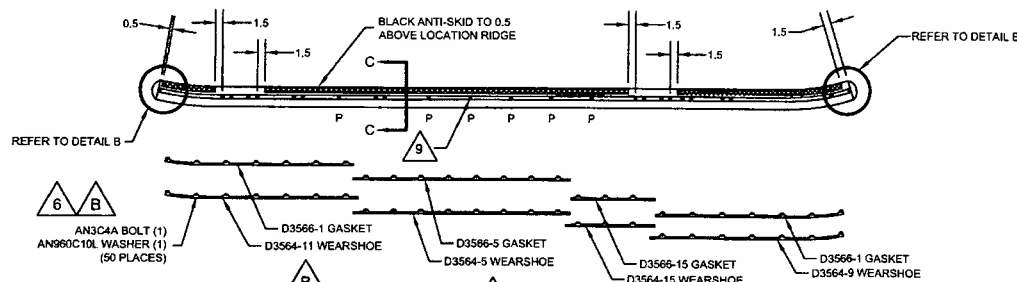
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**D2906-1 DRILLING DETAIL**

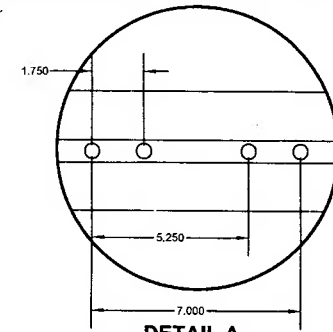


**D2906-041 BENDING AND CUTTING DETAIL**

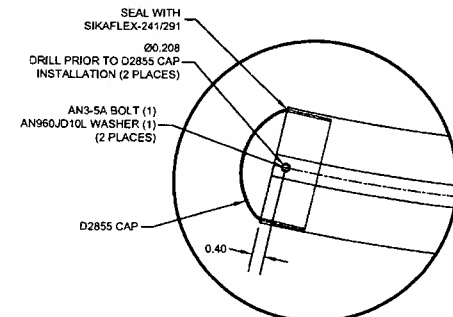


**D2906-041 ASSEMBLY DETAIL**

24935



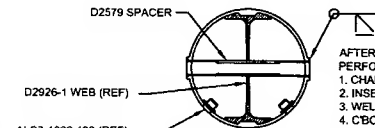
**DETAIL A**  
SCALE 1:4



**DETAIL B**  
SCALE 1:4

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**SECTION C-C**  
SCALE 1:4

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 00.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (22 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. CBORE D2579 SPACER TO 00.437 X 1.00 DEEP

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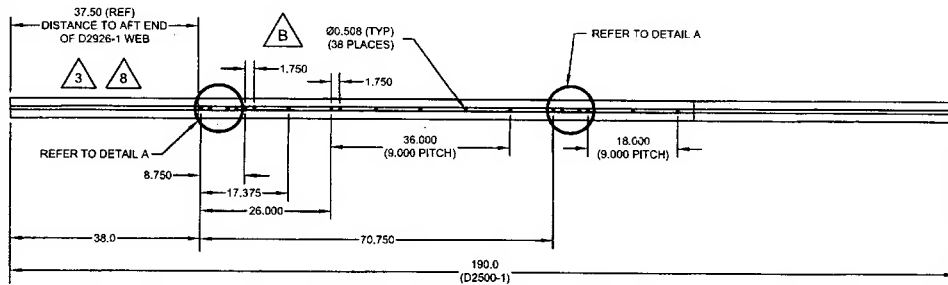
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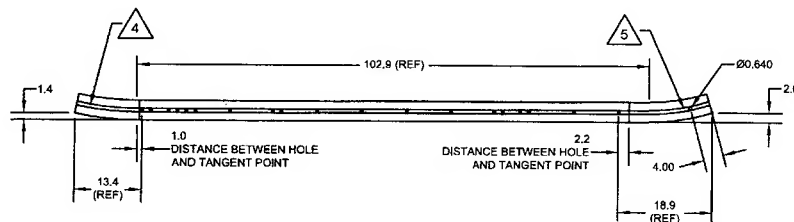
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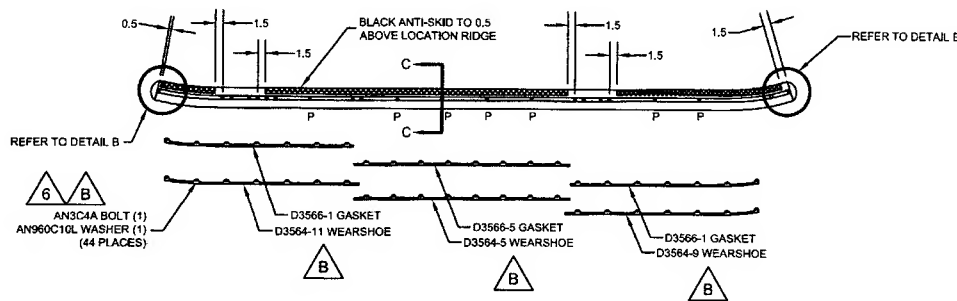
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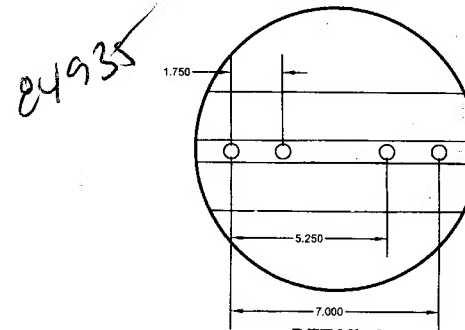
**D2906-3 DRILLING DETAIL**



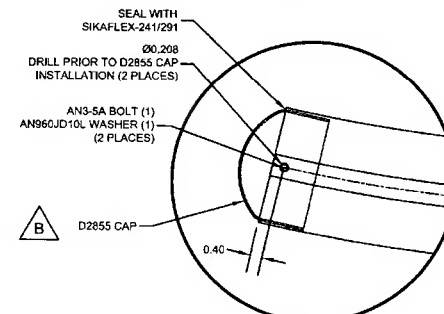
**D2906-043 BENDING AND CUTTING DETAIL**



**D2906-043 ASSEMBLY DETAIL**



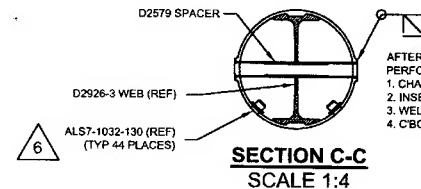
**DETAIL A**  
SCALE 1:4



**DETAIL B**  
SCALE 1:4

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